

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020052**Date Inspected:** 25-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Liu Hua Jie, Lu Li Qing, Geng W			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Orthotropic Box Girder( OBG)	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12CW, Deck Pannel Diaphragms, PP116.5.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector ZPMC Personnel performing fit up of Deck Pannel Diaphragms at DP3069-PP116.5. The attached photographs provide additional detail.

Assembly, Bay 14, 12CE, Bottom Plate & Side plate.

During Random Visual in process Inspection, this QA inspector observed ZPMC NDT personnel performing Ultrasonic testing (UT) on Bottom Plate & Side plate weld. The weld is identified as SEG3003A-002. The attached photographs provide additional detail.

Assembly, Bay 14, 12AW, Deck plate (DP3040A) to Deck plate (DP3041A).

SAW welding of weld joint SEG3004\*-008/026; located on assembly, Bay 14, 12AW. Welder is identified as 045265; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2221-LC-S-1.

Assembly, Bay 14, 12CE, Bottom plate to Side plate.

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SMAW Repair welding of weld joint SEG3003A-001 (WRR # TEMPORARY); located on assembly, Bay 14, 12CE. Welder is identified as 20113; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-4F(4G)-REPAIR-1.

Assembly, Bay 14, 12AE, CA6501.

FCAW welding of weld joint CA6501-004; located on assembly, Bay 14, 12AE. Welder is identified as 048038; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4B-F.

Assembly, Bay 13, Mock-Up for 13AE.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC carrying out Mock-Up for 13AE. This QA inspector noticed following things

- BP3032-004 welding in process.
- BP3032-006 welding in process.

Subassembly, Bay 03, Mock-Up for 13AE.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC carrying out Mock-Up for 13AE. This QA inspector noticed following things,

- FB3110A welding in process.
- FB3127A Tack welding in process.

Training for Phased Array Ultrasonic Testing.

This QA inspector attended Training for Phased Array Ultrasonic Testing (PAUT) from 1600Hrs. to 1900Hrs.

This QA Inspector carried out NDE on following

Blast shop 01, 9AW.

This QA inspector performs Random Visual Testing (VT) after blast; of area previously tested and accepted by ZPMC Quality Control personnel of 9AW (Interior). Indications found were documented & marked for further processing.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Juvekar,Amit

Quality Assurance Inspector

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**Reviewed By:** Miller,Mark

QA Reviewer